User:

Wednesday, 5/31/2006 7:36:22 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 27286

Estimate Number

: 10518

P.O. Number This Issue

AIU:

: 5/31/2006

: NC

: NA : 26160

S.O. No. : NIA

: MACHINED PARTS Type

Part Number

Drawing Name

: D28063

Drawing Number

: D2806 REV A : N/A

: BUSHING

Project Number **Drawing Revision**

Material **Due Date**

: 6/18/2006

Qty:

40 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est:B

Part now turned

. KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

HARDINGE CNC LATHE SMALL

1.0

M6061T6H1000

6061-T6 1" HexBar



Comment: Qty.:

0.0962 f(s)/Unit

Total: 3.8472 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: M19059

06/06/05

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

06/06/05

40

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/06/05

4.0

MILLING CONV.



Comment: CONVENTIONAL MILLING MACHINE

CONVENTIONAL MILLING MACHINE



Drill as per Dwg D2806

J.6

9m

06/06/06

40

40

5.0

QC8

Comment: SECOND CHECK

SECOND CHECK



40

Dart A	erospace	Lta							
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		•							
NOD			WORK ORD	ER NON-CONFORMANC	F (NCE	2)			
NCR:			TORIC ORD		_ (1101	•)			
		Description of NC		Corrective Action Section B			Verification	T	Approval
DATE	STEP	Section A	Initial	Action Description	Sign 8		ion C	Approval Design Mgr	Approval QC Inspector

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Verification	A = = = = = = = = = = = = = = = = = = =	Approval					
	STEP	Section A	Initial Design Mgr	Action Description Design Mgr		Section C	n Approval Design Mgr	Approval QC Inspector			
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Part No:	PAR #:	Fault Category:	NCR:	Yes (No) DQA:	Date: <u>06/06/69</u> -
NOTE: Date & initial all entries				QA: N	/C Closed:	Date:

Wednesday, 5/31/2006 7:36:23 AM Date: Uset: Kim Johnston **Process Sheet Drawing Name: BUSHING** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27286 Part Number: D28063 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 Comment: INSPECT ALODINE PACKAGING RESOURCE #1 PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 57386 Location:_ DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL u 0606.9 Inspection Level 21 Job Completion

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approva QC Inspecto
NCR:		V	VORK ORDE	R NON-CONFORMAN	CE (NCR	3			
NCK.	Ţ			Corrective Action Section B		- ,			
DATE	STEP	Description of NC Section A	Initial Design Mgr	Action Description Design Mgr	Sign &	Verification		Approval Design Mgr	Approva QC Inspecto
			Design Wgi	Design vigi	Date				
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Part No	· `	PAR #:	Fault Catagory	MCD.	/00 No	DOA:		Data	
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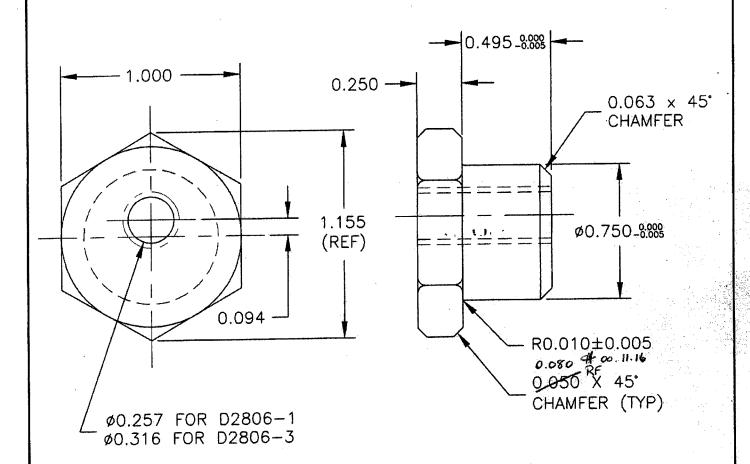
H:\forms\Quality Assurance\approved forms\NCRWO revC





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	DESIGN	DRAWN, BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
)	CHECKED	APPROVED	DRAWING NO. D2806	REV. A SHEET 1 OF 1
	DATE		TITLE	SCALE
	00.11.08		BUSHING	2:1
	Δ	00.11.08	NEW ISSUE	

ELEASED OD. 11.13



D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE

SHOP COPY RETURN TO

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 SUBJECT TO AMENDMEN BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 WITHOUT NOTICE TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROS	PACE LTD				Work Order:	272	86
Description:					Part Number:		
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Inspection Dwg:		· · · · · · · · · · · · · · · · · · ·				Pa	ge 1 of 1
	FIRST	ARTICLE IN	SPECTIO	ON CHE	ECKLIST		
		First Artic	le	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
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0.750	+ 0.000	0.748					-
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Rev Date	Change				Roy	ised by	Approved
A,	New Issue				KJ/I		Thhioned